

Date: Friday, 7/14/2006 12:01:27 PM
User: Kirk Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TOW RING		
Job Number	: 27924		Part Number	: D2968041		
Estimate Number	: 10396		Drawing Number	: D2968		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/14/2006 S.O. No.: N/A		Drawing Revision	: B1		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/20/2006 Qty: 40 Um: Each		
Previous Run	: 26210					
Written By	: <u>KJ</u> 06.07.14					
Checked & Approved By	: <u>KJ</u>					
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	27924A	STEM	<u>B27924A</u> <u>06/08/22</u> (41)
2.0	27924B	RING	<u>B26210B</u> <u>06/08/22</u> (41)
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	<u>06/08/22</u> (41)
4.0	QC5/9	WELD INSPECTION	<u>PD 06-08-22</u> (41)
5.0	PG	PURCHASING	<u>C 06/08/23</u> (41)
		Comment: PURCHASING Issue P/O: <u>1905</u> Description: D2968-041 to heat treat to ultimate tensile strength 125ksi as per Dwg D2968 Conformity sheet required	
		Issue P/O: <u>1906</u> Cad Plate per QQ-P-416F Class I Type II Conformity sheet required	<u>C 06/08/23</u> (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: Date: 06/09/09

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Friday, 7/14/2006 12:01:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 27924

Part Number: D2968041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

7/14/06/20 41

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CAD PLATE

Li 06/09/20

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

a.m 06-09-28 (41)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 09 28 (41)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5113

7/14/06/29 (41)

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/29 (41)

Job Completion



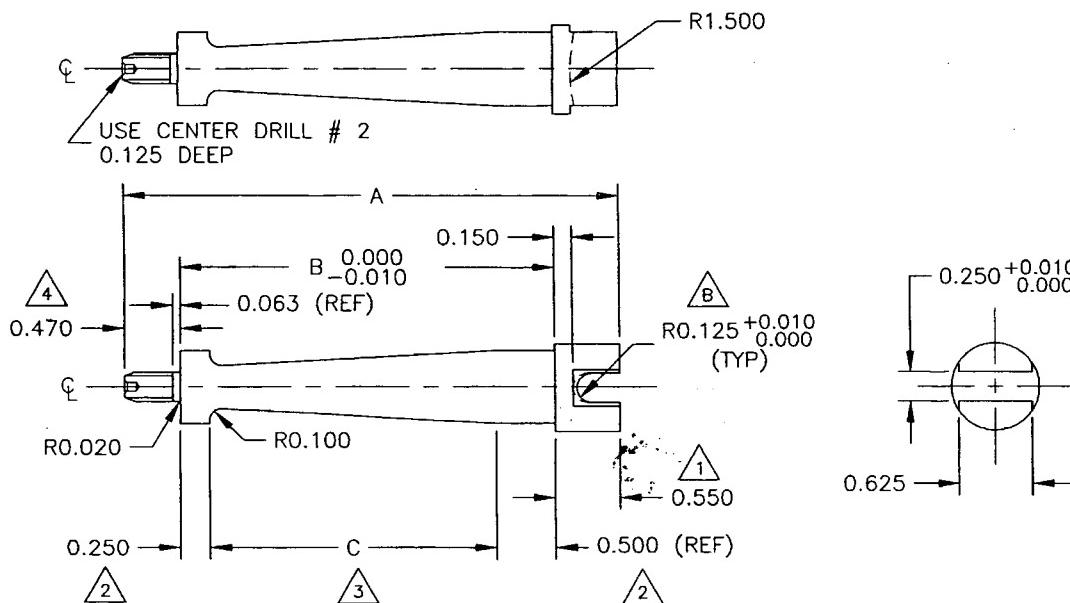
06/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

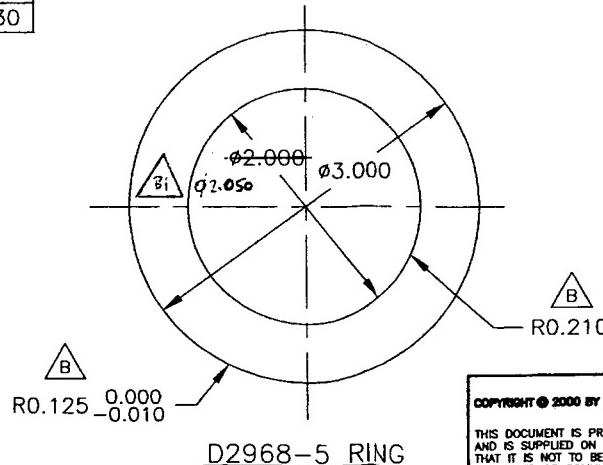
△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
TO Ø0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

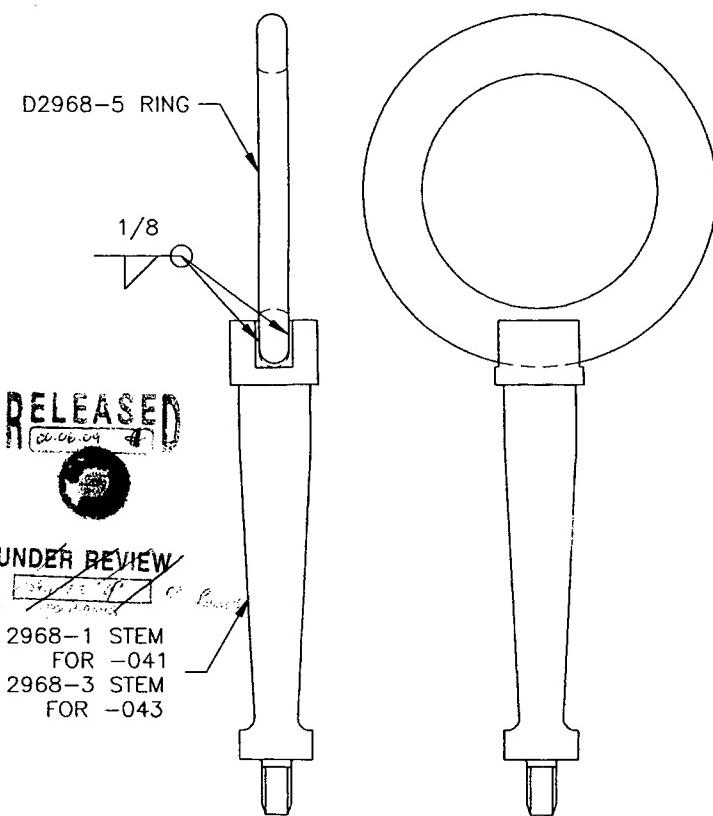
D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



D2968-5 RING



D2968-5 RING

1/8

RELEASED
04-06-04

UNDER REVIEW

USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
OSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART
checked	RF	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2968
DATE	REV. B	
00.05.31	SHEET 1 OF 1	
	SCALE	
	1:1	

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

NO. 27924

WITHOUT NOTICE
WORK ORDER
SHOP COPY
RETURN TO
ENGINEERING
CONTROLED COPY
SUBJECT TO AMENDMENT

MANCO
DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: 514-355-7867
Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

7132

Dant Aerospace LTD
Client / Customer

P01906

Votre # de commande / Your purchase order #

D2968-041 B27924
de la pièce / part

100387

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <i>Renault</i>	Date, équipe / Date, shift <i>Sept 18, 2006</i>
Placage / Plating <i>Cadmium yellow QQ P-416 F CLASS 1 Type II</i>	
Quantité totale / Total quantity <i>41</i>	Quantité inspectée / Inspected quantity <i>41</i>
Adhésion / Adhesion <i>Good</i>	
Épaisseur / Thickness L.C.D. <i>No</i>	H.C.D. Moy. / aver. <i>0.0005</i>
Coulisses, taches / Leach, spots <i>No</i>	Rugosité / Roughness <i>No</i>
Quantité approuvée / Approved quantity <i>41</i>	Quantité rejetée / Rejected quantity <i>—</i>

Commentaires / Comments

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

We herby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX



VAC AERO
INTERNATIONAL INC.

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6J 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C3
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

OAK 78660-2

09/14/2006

MM/DD/YYYY

PAGE: 1

TO: IDAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO DAMPLEX
4650 HICKMORE
ST. LAURENT, QC

K6A 1K7

H4T 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/14/2006	PUROLATOR 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
P000001905		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-041	TOW RING	EA	41	41	
	Process Specifications: HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18 HRC 27-32.5 MATERIAL: 4130		Procedure: 3906		
	B27924				100% HARDNESS TESTED <i>41 pcs → 31/32 Hrc</i>

NOTE: PARTS TO BE SHIPPED TO MANCO DAMPLEX

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



HEAT TREATING

VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

